

Work Order ID 131644-1

131644

Monday, April 20, 2015 4:09:08 PM

MAY 7th
Ship play

Page 1

Item ID: D206-628-031

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ LH - High Gear 407

Start Date: 4/20/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/8/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MF Date: 15-4-20 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100	Document Control	0.00	DAS 6 9-89						
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy blue file and type labels as per PPP D206-628-031 CHG 003							

DAS
26
9-89

4/x

mh 15-04-23

APR 27 2015

110	Pick Kit	0.00							
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110									
Packaging	Memo	0.00							

Packaging

4 APR 23 2015

DAS
06
9-89

DAS
02
9-89

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120									
QC	Memo	0.00							

Quality Control

DAS
26
9-89

DAS
26
9-89

4/x

APR 27 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																												
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Work Order ID 131644

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131644

Page 2

Item ID: D206-628-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear 407

Stop ***NS2***

Start Date: 4/20/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/8/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-031								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

slip 2
mt 15-5-7

MAY 07 2015

MLJ

mt
15-5-7

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 131644

131644

Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step™ LH - High Gear 407

Start Date: 4/20/2015

Required Date: 5/8/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP RevE as per ecn 1118 08-02-05 DD verified by:EC IPP Rev:F
as per chg 003 DD 10.02.25 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-13A Bolt		Purchased	No			110	Each	571.0000	4	16		DAS 6 9-89	DAS 02 9-89
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Location	Loc Qty	Loc Code
FG	20	
122808	20	
ST325A	200	
m131957	200	
ST344	351	
131677	351	

AN4-14A Bolt		Purchased	No			110	Each	218.0000	4	16		DAS 6 9-89	DAS 02 9-89
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Location	Loc Qty	Loc Code
FG	5	
122141	5	
ST325A	7	
131677	2	
M131153	5	
ST344	206	
M130716	15	
M131803	191	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 131644

131644

Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step™ LH - High Gear 407

Start Date: 4/20/2015

Required Date: 5/8/2015

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased No

110 Each 214.0000 4 16

AN4-15A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

38

120449

38

ST325A

176

m130358

8

m131320

68

m131957

100

D2724-041

Manufactured No

110 Each 0.0000 1 4

D2724-041

206L Step Assembly, LH

D2731-3

DAS
26
9-89

Manufactured No

110 Each 55.0000 4 16

D2731-3

Mounting Lug

Location

Loc Qty

Loc Code

ST520

51

119211

3

123541

48

ST538

4

126661

4

D2732-030

Manufactured No

110 Each 106.0000 8 32

D2732-030

Rubber Cushion - 3"

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

2

107346

2

117118

42

124849

60

DAS
6
9-89

DAS
6
9-89

APR 23 2015

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Picklist Print

Monday, April 20, 2015 4:09:07 PM

Page 3

Work Order ID: 131644

131644

Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step™ LH - High Gear 407

Start Date: 4/20/2015

Required Date: 5/8/2015

Start Qty: 4.00

Required Qty: 4.00

D3394-041

Manufactured No

110

Each

70.0000

4

16

D3394-041

Lug

**

DAS

06

9-89

DAS

02

9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST528

66

124892

24

129578

40

74505

2

ST538

4

126662

4

DAS
26
9-89

14

2

MS21042L4

Purchased

No

110

Each

1,437.000

12

48

MS21042L4

Locknut

**

DAS

6

9-89

DAS

02

9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

574

m127813

574

ST260a

278

m130799

56

m131803

222

ST305

543

426

426

m128300

8

m130922

97

m131618

12

DAS
26
9-89

48

APR 23 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Monday, April 20, 2015 4:09:07 PM

Page 4

Work Order ID: 131644

131644

Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step™ LH - High Gear 407

Start Date: 4/20/2015

Required Date: 5/8/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

110

Each

5,484.000

12

48

NAS1149D0463.J

WASHER

**

APR 23 2015

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

5443

M129682

86

M130799

403

M132035

4954

DAS
26
9-89

DAS
6
9-89

DAS
02
9-89

48

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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REF

DART AEROSPACE USA, INC.

APR 27 2015

DAS
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9-89

IIN-D206-628

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5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-
STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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Revision: G
Date: 11.02.25

